

Date: Wednesday, 13/08/2008 10:55:13 AM
 User: Julie Lecocq

W/O split for # -3 of Qty 1

Process Sheet

0809.06

split

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: GLARESHIELD ASSEMBLY
Job Number	: 41207-2		
Estimate Number	: 13291		
P.O. Number	:	Part Number	: D3690041
This Issue	: 13/08/2008 S.O. No. :	Drawing Number	: D3690 REV B
Prsht Rev.	: NC	Project Number	:
First Issue	: 1/1 Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 41018	Material	:
Written By	:	Due Date	: 01/09/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>JUL 08.8.13</u>		
Comment	: Est Rev:A 08-04-29 new issue DD verified by:ec Est Rev:B 08-07-14 revB as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D36901	Glareshield
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)
 Glareshield
 batch: 41222 / 1/1021 B 40664 SB 08/09/08 (3)

3.0	D3697041	Tube Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)
 Tube Assembly
 batch: 40665 @ 1 / 4/1021 @ 2 FF 08/09/08 (3)

4.0	D36981	Support Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)
 Support Angle
 batch: 341022 B 41656 SB 08/09/08 (3)

5.0	AN960JD3	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 18.0000 Each(s)
 Washer
 batch: 17107989 24000 FF 08/09/08 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3690-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: <u>41207</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080828	4.0	All D3698-1 B41022 & B40666 Angles are scrap. 2 D3690-041s were drilled to try and install the D3698-1. R.C. error on the angles was never noticed, and part was curving inside the 5.50" dimension, and parts were not (The D3698-1's) were not measured along, as they were drilled. Lack of Attention.	/as1u12	scrap & destroy the D3698-1 B41022, and pull from stock B40666 to scrap.	SB 08/08/29	08-09-03	/as1u12	/as1u12
			/as1u12	See NCR 08-080.	SB 08/08/29	08-09-03	/as1u12	/as1u12
08/09/05	8	Open hole at .129 and Prop Rivet for change CR 3213-4-03 Instead Rivet MS20470AD3-5	##	ACCEPTABLE PERMANENT	## 08-09-05		/as1u12	/as1u12

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:55:13 AM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: GLARESHIELD ASSEMBLY

Job Number: 41207

Part Number: D3690041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

MS20426AD34

04-4

08-09-09

RIVET



(PTU)

Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

RIVET

batch: M105970

FF

08/09/08

(3)

7.0

MS20470AD34

CR3213-4-03

Rivet, Universal Head

08.09.05



(PTU)

Comment: Qty.: 35.0000 Each(s)/Unit Total: 105.0000 Each(s)

Rivet, Universal Head

batch: M15541

M16896 08.09.05

FF 08/09/08

(3)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690

FF 08/09/08

(3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/08 (+3)

(Pn)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location:

41185
4107

u/h Soubelog

8/9/05

BY

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/15

Job Completion



Soubelog
10.0 - Identify and stock

u 08-09-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/09/03	7.0	MS20470AD3-5 are required perm change: update	/	N/A	/	08-09-03	08-09-03	
08/09/04	7.0	replace MS20470AD-3 CER 274553 to CR321 perm - change update dwg D3690 Rev.C.	MSB	08.09.22		08-09-03	08-09-15	

Part No: D3690-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: 41207		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.09.03	8.0	Hole MARKED B ON DWG HAS ENLARGED WHILE REMOVING RIVET PER REWORK ON W.O.C. ABOVE.	08.09.03	REPLACE MS20470AD3-5 WITH MS20470AD4-5 FOR M LOG 918 THIS W/O ONLY (QTY=1).	FF 08/09/09	08.09.05	08.09.03	08.09.05
08.09.08	8.0	1 part, The original rivets are pressed into the gasketed upon Assy on the D3697-041. Also 1 hole is enlarge around the rivet. MS20470AD4-5 (above) R.C: Lack of attention upon re-work	08/09/08	Remove: Replace carefully the D3697-041, 1x3 1x D3697-041 341221 1x D3697-041 341221	FF 08/09/09	08.09.09	08.09.08	08.09.08
08.09.08	8.0	hole is enlarged around 1x CER 274553-4 rivet, & another was drilled and installed through the original MS20470AD3-5 rivet. R.C: Lack of attention & carelessness	08/09/08	Remove & replace carefully the D3697-041 at 1x D3697-041 341221 weld holes carefully per as 1004 Qty 3	FF 08/09/09	08.09.09	08.09.08	08.09.08

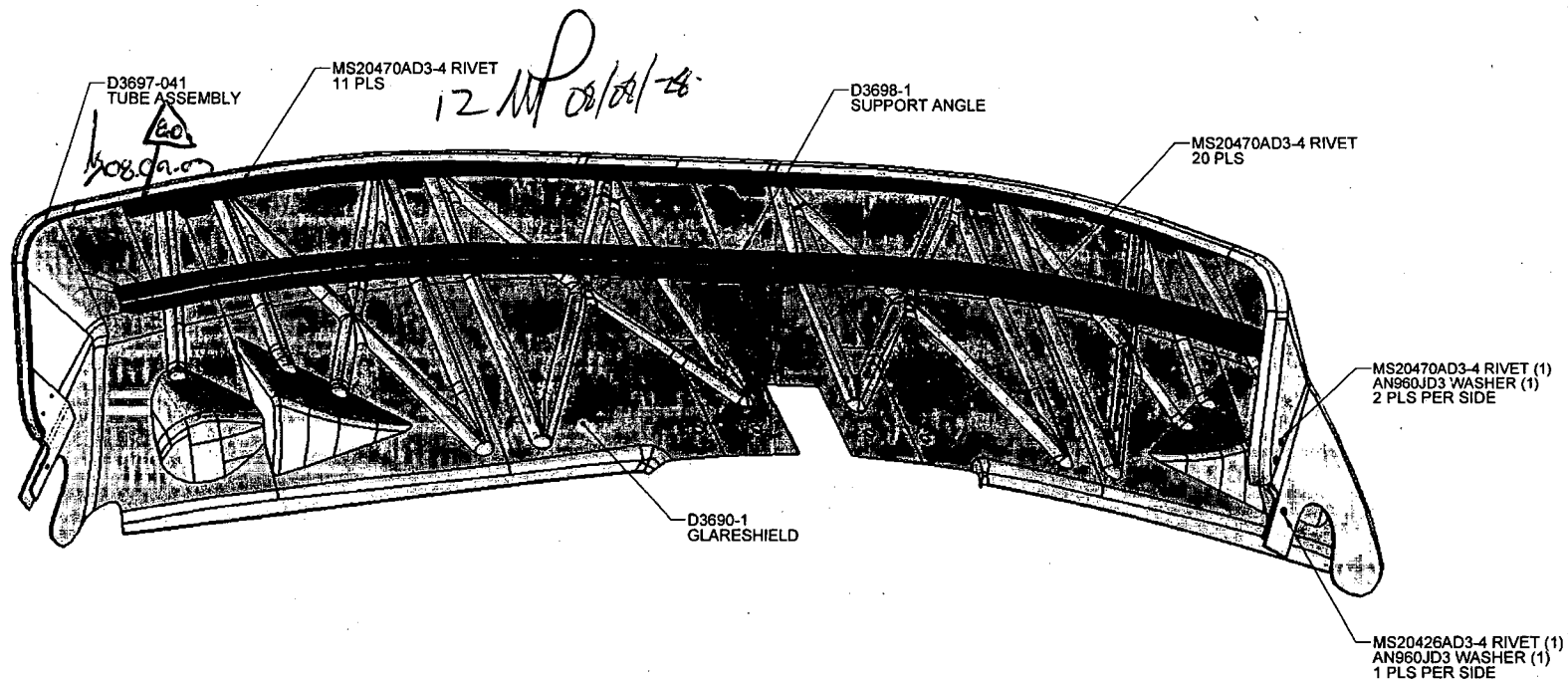
NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/09	# 9.1	Permanent change SPRY Paint AS per OST 005 4.2. FLAT BLACK using GUNBRIT 22. <u>M 08 09 15</u>	MA	08/09/08		08-09-08	08/09/08	
08/09	# 9.2	Inspect SPRY Paint QCL4 <u>08-09-15 (2)</u>	MA	08/09/08		08-09-08	08/09/08	

Part No: D3690-041 PAR #: N/A Fault Category: Prod / Pkg. Ass' mat 650001 NCR: Yes No DQA: 2 Date: 08/09/08
D412-776
Resolution: Rework Disposition: QA: N/C Closed: 2 Date: 08/09/09

NCR: <u>41207</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-09-09	6-0	Hole was slightly oversized when removing the 3-4 rivets.	08/09/09	Replace with a Qty 2 of 4-4 rivets. <u>M 1021</u> and washers <u>AN960JD4</u> <u>M 11735</u>	08/09/09 FF	08-09-15	08-09-09 08/09/09	08-09-09
		Hole was slightly oversized when removing the 3-5 and replace	08/09/09	Replace with Qty 4 of 4-5 rivet <u>M 107820</u> washer	08/09/09 SS	08-09-15	08/09/09	08-09-15
		washer <u>AN960JD3</u> for <u>AN960JD6</u>	08/09/09	<u>AN960JD6</u> <u>M 12085</u>	08/09/09 SS	08-09-15	08/09/09	08-09-15

NOTE: Date & initial all entries



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3690-041	GLARESHIELD ASSEMBLY
1	D3690-1	GLARESHIELD
1	D3697-041	TUBE ASSEMBLY
1	D3698-1	SUPPORT ANGLE
6	AN960JD3	WASHER (OR NAS1149DN332J)
2	MS20426AD3-4	RIVET
35	MS20470AD3-4	RIVET

D3690-041 GLARESHIELD ASSEMBLY

RELEASED
08-07-05 MP

B	ADD FINISH COAT & 1.0 TYP. SHEET 2 ZONES A,B & C,5; ADD MIN THICKNESS. SHEET 3 ZONE A,8	RF	08.06.24
A	NEW ISSUE	RF	08.05.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3690	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GLARESHIELD ASSEMBLY	NTS
DATE	08.06.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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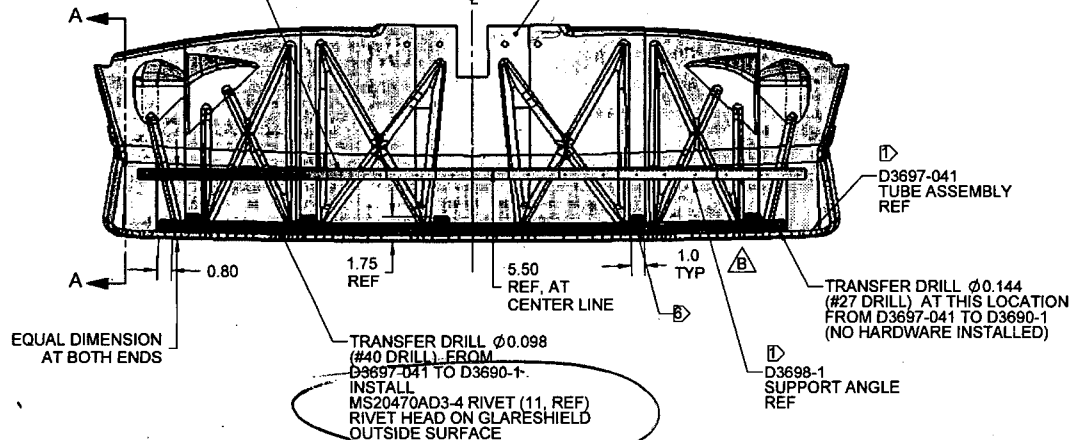
TRANSFER DRILL $\phi 0.098$
(#40 DRILL) FROM
D3698-1 TO D3690-1
INSTALL
MS20470AD3-4 RIVET (20, REF)
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3690-1
GLARESHIELD
REF

TRANSFER DRILL $\phi 0.098$
(#40 DRILL) FROM
D3697-041 TO D3690-1
INSTALL
MS20426AD3-4 RIVET (1, REF)
AN960JD3 WASHER (1, ON GLARESHIELD
OUTSIDE SURFACE)
1 PER SIDE

TRANSFER DRILL $\phi 0.098$
(#40 DRILL) FROM
D3697-041 TO D3690-1
INSTALL
MS20470AD3-4 RIVET (1, REF)
AN960JD3 WASHER (1, ON GLARESHIELD
OUTSIDE SURFACE)
2 PER SIDE

SECTION A-A

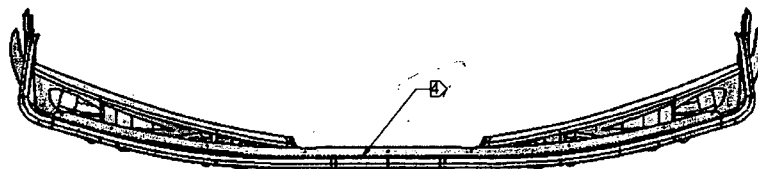


EQUAL DIMENSION
AT BOTH ENDS

TRANSFER DRILL $\phi 0.098$
(#40 DRILL) FROM
D3697-041 TO D3690-1.
INSTALL
MS20470AD3-4 RIVET (11, REF)
RIVET HEAD ON GLARESHIELD
OUTSIDE SURFACE

D3698-1
SUPPORT ANGLE
REF

D3697-041
TUBE ASSEMBLY
REF






D3690-041 GLARESHIELD ASSEMBLY

RELEASED
68-07-05-74

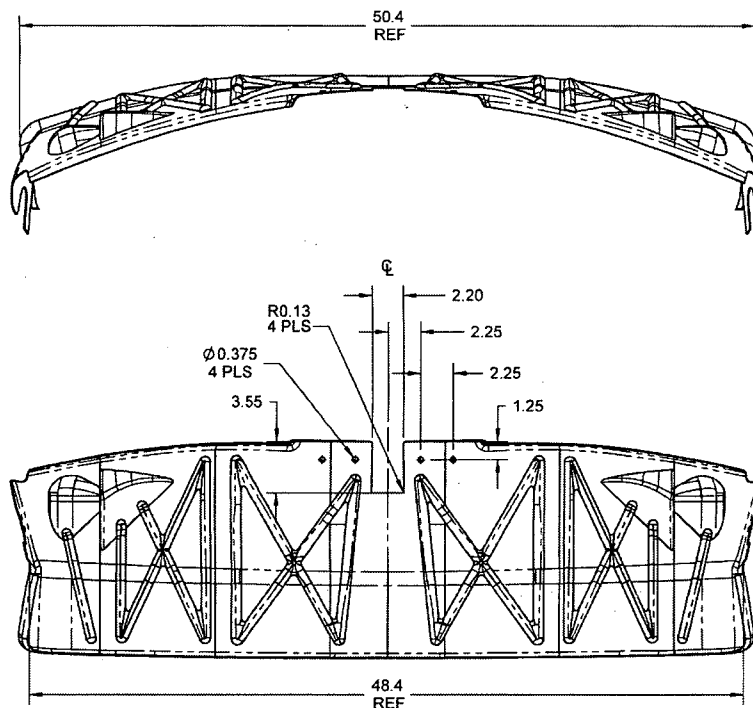
NOTES:

- 1) CENTER D3697-041 AND D3698-1 ON TO D3690-1
- 2) FINISH: PAINT D3690-041 ASSY FLAT BLACK USING BASF GLASURIT 22 LINE CODE SFA39.50 PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: ETCH WITH DART P/N D3690-041 & B/N ON INSIDE OF PART
- 5) WEIGHT: 2.98 lbs
- 6) MASK HATCHED AREAS (6 PLS) ON INSIDE OF THE PART PRIOR TO PAINTING



DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3690	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	
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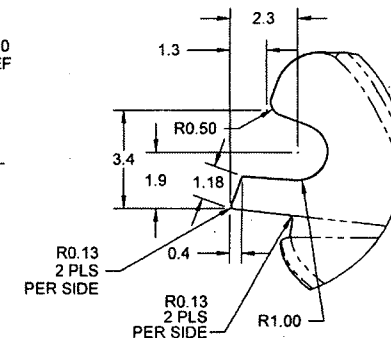
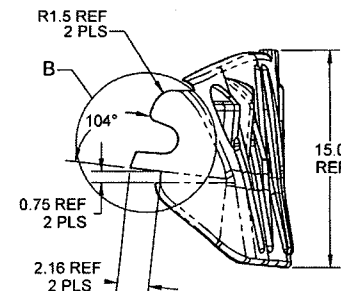
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D3690-1 GLARESHIELD



NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED 701 BLACK FLAT LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 2) TOOLING: THERMOFORM PER MOLD DT9010 PER QSI 022
TRIM PER MOLD SCRIBE LINES EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 2.5 lbs
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.040



DETAIL B
2x SCALE
ALL REF DIMENSION

RELEASED
08-09-2007

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3690	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GLARESHIELD ASSEMBLY	NTS
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